



Dart Aerospace Ltd.
1270 Aberdeen St
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D205-626-011
Job Sheet 190701



Part No: D205-626-011

Job Qty: 1 pcs

Part Name: Hell-Access-Handle™ LH

Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/13/19

Job Tracking No:

Due Date: 3/29/19

Created By: Marie Lajeunesse

Type: Stock

Description: SIOP

Note: DWG REV C IPP Rev:B Reformat 00-03-03 EC

Ship Via:

chgo02 reattachement

Bill of Materials

DAS 21 9-89
DAS 35 9-89

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Hrs	Run Hrs	Workcenter/Supplier	Sign-off
110	Packaging 1 - Pick Kit	1 pcs	3/29/19		0.00	0.00	Packaging 1 - 1	
							Packaging 1 - 2	
							Packaging 1 - 3	
							Packaging 1 - 4	
							Packaging 1 - 5	
							Packaging 1 - 6	
							Packaging 1 - 7	
							Packaging 1 - 8	
							Packaging 1 - 9	
							Packaging 1 - 10	
							Packaging 1 - 11	
							Packaging 1 - 12	
							Packaging 1 - 13	
							Packaging 1 - 14	
							Packaging 1 - 15	
							Packaging 1 - 16	
							Packaging 1 - 17	
							Packaging 1 - 18	
							Packaging 1 - 19	
							Packaging 1 - 20	
							Packaging 1 - 21	
							Packaging 1 - 22	
							Packaging 1 - 23	
							Packaging 1 - 24	
							Packaging 1 - 25	
							Packaging 1 - 26	
							Packaging 1 - 27	
							Packaging 1 - 28	
							Packaging 1 - 29	
							Packaging 1 - 30	
							Packaging 1 - 31	

Rosales, Oscar

Mon 9-16-2019

(044931)



Dart Aerospace Ltd.
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Container No: S213959



Part: D205-626-011

Job No: 190701

Serial No/Batch: S213959

Revision:

Inspector:

Exp Date:

Instructions: TC STC SH96-109 Issue 1, CAN STC SR0054

115 QC 4	1 pcs	3/29/19	0.00 0.00	Packaging 1 - 32	
				Packaging 1 - 33	
				Packaging 1 - 34	
				Packaging 1 - 35	
				QC 4 - 26	
				QC 4 - 28	
				QC 4 - 42	
				QC 4 - 58	
				QC 4 - 6	
				QC 4 - 69	
				QC 4 - 9	
				QC 4 - 46	
118 Packaging 3-1 - Stock - B4B	1 pcs	3/29/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
120 QC 21 - FG	1 pcs	3/29/19	0.00 0.00	QC 21 - FG - 21	
				QC 21 - FG - 70	
				QC 21 - SA - 53	

Max B - 9/18/2019

Max B - 9/18/2019

Close wo only JK

DAS
21
9-59

SEP 19 2019

Part Op 110 - (Pick Kit)
 Descriptions: 115 - (QC4- 100% inspect kits for completeness)
 118 - (Identify as per dwg & Stock Location: _____)
 120 - (QC21- Final Inspection - Work Order Release)

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
AN526C632R7	Screw	6 Ea (6 ea) ✓	110-Packaging 1 - Pick Kit	5107451 ✓
D2480-011	Handle Weldment LH	1 pcs (1 ea) ✓	110-Packaging 1 - Pick Kit	5165186 ✓
MS21042L06	Nut	6 Ea (6 ea) ✓	110-Packaging 1 - Pick Kit	5198110 ✓
NAS1149DN632J	Washer	6 pcs (6 ea) ✓	110-Packaging 1 - Pick Kit	5193518 ✓
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-Packaging 1 - Pick Kit	AN526C632R7	6	96	0
	D2480-011	1	0	0
	MS21042L06	6	285	0
	NAS1149DN632J	6	496	0
Part Specifications				
Specifications could not be found.				

Plex 2/13/19 1:11 PM Dart.lajeunesse.marie

011931

Mon 9-16-2019

Rosales, Oscar

Entered: _____

Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No.: _____		DISPOSITION Rework ☐ ☐ Scrap ☐ ☐ Use-as-is ☐ ☐		DEPARTMENT/PROCESS Skid-tube ☐ ☐ ☐ ☐ Machining ☐ ☐ ☐ ☐ Large Fab ☐ ☐ ☐ ☐		Cross tube ☐ ☐ ☐ ☐ Small Fab ☐ ☐ ☐ ☐ Finishing ☐ ☐ ☐ ☐		Eng. (Non-AW) ☐ ☐ ☐ ☐ Prod. Eng. Coord. ☐ ☐ ☐ ☐ Rec/Store/Packaging ☐ ☐ ☐ ☐		Engineering ☐ ☐ ☐ ☐ Water Jet ☐ ☐ ☐ ☐ Supplier ☐ ☐ ☐ ☐ Quality ☐ ☐ ☐ ☐		Date : _____		Sequence #: _____		QTY Affected : _____		MRB (QSI042) _____					
Description Work Order Deviation						Disposition																	
Root Cause Operator ☐ ☐ ☐ ☐ Manufacturing Process ☐ ☐ ☐ ☐ Equip/Tooling ☐ ☐ ☐ ☐ Handling/Preservation ☐ ☐ ☐ ☐ Material ☐ ☐ ☐ ☐ Product Improvement ☐ ☐ ☐ ☐ Process Improvement ☐ ☐ ☐ ☐ Human Factors ☐ ☐ ☐ ☐						FAULT CATEGORY Contamination ☐ ☐ ☐ ☐ Misaligned/off center ☐ ☐ ☐ ☐ BOM/Route ☐ ☐ ☐ ☐ Broken/Damage/Defect ☐ ☐ ☐ ☐ Incomplete/Unclear Instructions ☐ ☐ ☐ ☐ Drill Holes ☐ ☐ ☐ ☐ Fit/Function ☐ ☐ ☐ ☐						Power Loss/Surge ☐ ☐ ☐ ☐ Folio/Program ☐ ☐ ☐ ☐ Grain Direction ☐ ☐ ☐ ☐ Weld ☐ ☐ ☐ ☐ Wrong Stock Pulled ☐ ☐ ☐ ☐ Out of Sequence ☐ ☐ ☐ ☐ Off-set/Set-up ☐ ☐ ☐ ☐						Positioned Wrong ☐ ☐ ☐ ☐ Outside Tolerance ☐ ☐ ☐ ☐ Drawing ☐ ☐ ☐ ☐ Finish ☐ ☐ ☐ ☐ Part Lost/Missing ☐ ☐ ☐ ☐ Misread ☐ ☐ ☐ ☐					
						Pressure/Forced ☐ ☐ ☐ ☐ Bending ☐ ☐ ☐ ☐ Crushing ☐ ☐ ☐ ☐ Cracks ☐ ☐ ☐ ☐ Crimp/Kink/Ripple/Wave/Twist ☐ ☐ ☐ ☐ Marks/Chatter ☐ ☐ ☐ ☐ Mislabeled ☐ ☐ ☐ ☐						Other/Details: _____											
Completed By _____						Lead hand / Supervisor _____																	
QC / QA Coordinator _____																							

4. WEIGHT AND BALANCE

The following is the net weight increase associated with the D205-626 Kits.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D205-626-011	1.3 lb	-46.5 in	-60.5 in-lb	87.2 in	113.4 in-lb
Heli-Access-Handle Kit™, LH	0.59 kg	-1.18 m	-0.70 m-kg	2.21 m	1.31 m-kg
D205-626-012	1.3 lb	46.5 in	60.5 in-lb	87.2 in	113.4 in-lb
Heli-Access-Handle Kit™, RH	0.59 kg	1.18 m	0.70 m-kg	2.21 m	1.31 m-kg
D205-626-013	1.3 lb	-50.5 in	-65.7 in-lb	87.2 in	113.4 in-lb
Heli-Access-Handle Kit™, LH (Spacedoor™)	0.59 kg	-1.28 m	-0.76 m-kg	2.21 m	1.31 m-kg
D205-626-014	1.3 lb	50.5 in	65.7 in-lb	87.2 in	113.4 in-lb
Heli-Access-Handle Kit™, RH (Spacedoor™)	0.59 kg	1.28 m	0.76 m-kg	2.21 m	1.31 m-kg

5. PARTS LIST

Qty -011	Qty -012	Qty -013	Qty -014	Part Number	Description
1				D205-626-011	HELI-ACCESS-HANDLE™, LH (STANDARD)
	X			D205-626-012	HELI-ACCESS-HANDLE™, RH (STANDARD)
		X		D205-626-013	HELI-ACCESS-HANDLE™, LH (SPACEDOOR™)
			X	D205-626-014	HELI-ACCESS-HANDLE™, RH (SPACEDOOR™)
1		1		D2480-011	HANDLE ASSEMBLY, LH
	1		1	D2480-012	HANDLE ASSEMBLY, RH
		2	2	D2481	DOUBLER
		2	2	80-005-1-8	INSERT
6				AN960C832R7	SCREW
6				MS21042L06	NUT
		4	4	MS21042L08	NUT
		2	2	MS27039-0805	SCREW
		4	4	MS27039-0809	SCREW
6				NAS1149DN632J	WASHER (OR AN960JD6)
		10	10	NAS1149FN816P	WASHER (OR AN960-8L)

A. T. A. 2

1

D205-626-011/-012

HELI-ACCESS HANDLE, LH/RH, STANDARD

[illegible]